

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017464**Date Inspected:** 17-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly Yard:

This QA Inspector observed the following work in progress:

OBG Seg 11AE:

Repair welding of weld joint no: SEG066A-014. Welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 040320 and was observed welding in the 1G position. ZPMC Quality Control (QC) was identified as An Qing Xiang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-1G(1F)-FCM-Repair-1. Repair welding was done as per Critical Welding Repair Report (CWR): CWR-2044 Rev-1.

OBG Seg 11AW:

Repair welding of weld joint no: SEG065A-011. Welding process was identified as SMAW. The welder was identified as 040611 and was observed welding in the 4G position. ZPMC QC was identified as Zhou Peng. The

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welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR-16026 Rev-0.

Repair welding of weld joint no: CA079-005. Welding process was identified as SMAW. The welder was identified as 040611 and was observed welding in the 2G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair-1. Repair welding was done as per WRR: B-WR-16011 Rev-0.

OBG Seg 11BW:

Repair welding of weld joint no: SEG067A-043. Welding process was identified as SMAW. The welder was identified as 040611 and was observed welding in the 4G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per WRR: B-WR-16026 Rev-0. See attached photo for further details.

OBG Seg 11AW and Seg 11BW:

Repair welding of weld joint no: OBW11B-002. Welding process was identified as SMAW. The welder was identified as 040656 and was observed welding in the 3G position. ZPMC QC was identified as Zhou Peng. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair-1. Repair welding was done as per WRR: B-WR-16012 Rev-0.

OBG Seg 10CW:

The SMAW process on weld joint no: OBW10E-023 and 024. The welder is identified as 041713 and was observed welding in the 4F position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-P-2114-FCM-1.

OBG Seg 10AW:

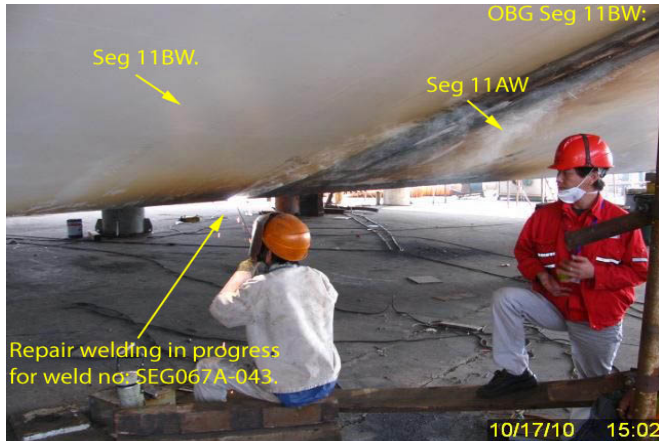
Punch list item no: 204:

This QA Inspector did visual inspection of weld joint no: FB023-008-125. Welding of this joint was observed to be completed and complying with the drawing requirement.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer